



Dart Aerospace Ltd.
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D4854-5
Job Sheet 170114



Part No: D4854-5

Job Qty: 10 ea

Part Name: Lower Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Due Date: 1/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D4854 rev.B SHEET 3 IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS IPP REV:B 17.12.01 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/25/18	1/25/18	0.00	0.00	Start Up Waterjet		OK 18 01/14
100	Waterjet	10 pcs	1/25/18	1/25/18	0.00	2.50	Waterjet1		OK 18 01/14
105	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC2 Waterjet-1		OK 18 01/14
110	Mill Conv	10 pcs	1/25/18	1/25/18	0.00	12.66	Mill Conv 1		J.C.-L. 18-01-26
130	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC8		B.A 18-01-29
140	HandFinish	10 pcs	1/25/18	1/25/18	0.00	0.04	HandFinish1		B-01-31/8
150	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC7-4		BEB 18-02-01
160	Powdercoat	10 pcs	1/26/18	1/26/18	0.00	0.50	Powdercoat1		BL 18-02-01
170	QC	10 pcs	1/26/18	1/26/18	0.00	0.00	QC3		11 FEB 0
180	Packaging	10 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3-2		9-89 SL
190	QC21-SA	10 Ea	1/26/18	1/26/18	0.00	0.00	QC21		DAB 21 FEB 02 2018

Part Op 100 - CUT AS PER FILE DWG REV: B PROG REV: B DEBURR
Descriptions: 110 - MILL RADS DRILL HOLES AS PER DWG DEBURR OPEN SLOT TO .260" AS PER DWG
160 - ***MASK AS PER DWG*** START TIME: 1:50 OVEN TEMPERATURE: 320 FINISH TIME:

M 138467.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.750X04.000	4	32	0	0

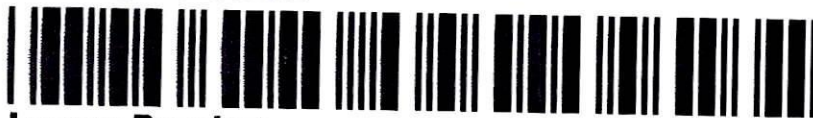
Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Bracket	4.450Inches ± 0.030	4.480 4.420		
2	Lower Bracket	3.500Inches ± 0.030	3.530 3.470		
3	Lower Bracket	2.300Inches ± 0.030	2.330 2.270		
4	Lower Bracket	0.750Inches ± 0.030	0.780 0.720		
5	Lower Bracket	0.260Inches ± 0.005	0.265 0.255		
6	Lower Bracket	2.230Inches ± 0.030	2.260		

DART
AEROSPACE
S032420

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Lower Bracket

PART NO: D4854-5

Original Serial #: S032420

Revision:

Operation: Start up Operation 01/15/18

Change No:

Job No: 170114

			2.200	
7	Lower Bracket	0.300Inches $\pm$ 0.030	0.330 0.270	
8	Lower Bracket	0.750Inches $\pm$ 0.030	0.780 0.720	
9	Lower Bracket	0.257Inches $\pm$ 0.005 - 0.001	0.262 0.256	Diameter
10	Lower Bracket	3.700Inches $\pm$ 0.005	3.705 3.695	
11	Lower Bracket	1.880Inches $\pm$ 0.030	1.910 1.850	
12	Lower Bracket	1.250Inches $\pm$ 0.010	1.260 1.240	

Plex 1/10/18 12:27 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					